

Work Order ID 73302

Wednesday, August 31, 2011 10:46:16 AM

Page 1

Item ID: D3455-1

Accept

Revision ID:

Item Name: Spacer

Start Date: 9/1/2011 Start Qty: 16.00

Required Date: 9/15/2011 Req'd Qty: 16.00

Reference:

Approvals:

Process Plan: *MF*

Date: *1-09-01*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3455

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

HARDINGE COBRA 1-TURN AS PER FOLIO FA583 & DWG D3455
FOLIO REV: *WA* DWG REV: *A* 2-DEBURR AS REQUIRED

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

40 *0*

40 *0*

40 *0*

SL 11/21/19

SL 11/21/19

B.A 11/09/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73302

Wednesday, August 31, 2011 10:46:16 AM



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Item ID: D3455-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 9/1/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

Handwritten: WA 11-9

Handwritten: 40

Handwritten: 0

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Handwritten: WA 8

150

0.00



Identify as per dwg & Stock Location: *Handwritten: ST 54*

Packaging

Memo

0.00

Packaging

Handwritten: 40x SP 11-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 73302

Wednesday, August 31, 2011 10:46:16 AM



Page 3

Item ID: D3455-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 9/1/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/20 [Signature]
MF
11-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

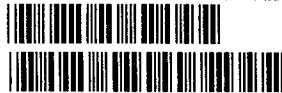
Wednesday, August 31, 2011 10:46:13 AM

Page 1

Work Order ID: 73302

Parent Item: D3455-1

Parent Item Name: Spacer




Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.000  Delrin Round Bar 1"		Purchased	No			100	f	41.2180	0.022	0.370526			

Location

Loc Qty

Loc Code

MAT055

41.218

117985

0.407

~~118257~~

24.811

118392

16

~~550~~ - 600

W/O:		WORK ORDER CHANGES					
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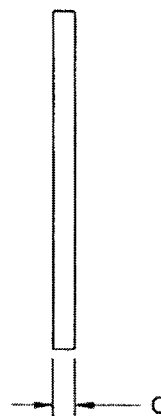
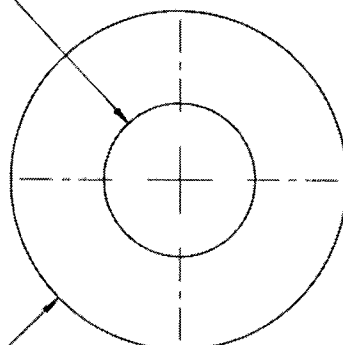
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3455	REV. A SHEET 1 OF 1
DATE 05.09.02		TITLE SPACER	SCALE 2:1
A	05.09.02	NEW ISSUE	

RELEASED

05.12.09 [Signature]

$\phi A^{+0.005}_{-0.000}$

ϕB



D3455-X

1) SPECIFICATION: D3455-X SPACER

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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